Work Order ID 105801

August-19-13 11:28:01 AM

105801

Page 1

D3121-144 D 3 1 2 1 - 1 4 4 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Bracket Assembly Item Name: 8/19/13 Start Oty: 8.00 *8* **Start Date: Cust Item ID:** Req'd Qty: 8.00 Required Date: 9/03/13 **Customer:** Reference: Start Run Process Plan: _ MLゴ Date: 13-08-19 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Reject Tool ID Reject Accept Insp. Work Center ID Description Code **Run Hours Qty Oty** Number Stamp Draw Nbr **Revision Nbr** D3121 Rev E 100 0.00 BAND SAW *100* Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blanks: (1.250" x 2.000") 4.425" long 110 0.00 HAAS CNC VERTICAL MACHINING #1 113-09-13 8 6 *110* 0.00 HAAS 1 Memo HAAS CNC vertical machine #1 1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-1142-Deburr3-Scribe batch number 120 QC2- Inspect parts off machine FAI/FAIB 0.00 113-09-13 8 0 OC 0.00 Memo Quality Control

											DQA:	Date:	
NCR:	'es	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UPDATE				
											QA Closed:	Date:	
Nork Orde	er:					DISPOSITION			AGAINST	DEP	ARTMENT	PROCESS	
Part N	•					Rework Scrap Use-as-is		P	Skid-tube Crosstube Wachining Small Fab noforming Finishing	įП		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	ю.					Work Order Update		1	Large Fab Composite	_		Supplier	
Root					Descr	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
oc/Data													
quip/Tooling													_
perator	_												•
Material	\dashv								, , , , , , , , , , , , , , , , , , ,				
etup	_												
ther													
rocess													
upplier raining													
Inapproved							1						
паррточец			l <u></u>	<u> </u>		<u> </u>	FAUL	T CATE	GORY				
Landi	ng G	Gear				General							
		Bending			. [Bend		Grain			Ovalized	Γ	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		art Incorred	t	Weld
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclear	∐ F	art Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	∐F	art Moved		
		Heat Trea	it			Countersink		Mislabe	led	\vdash	ositioned V		_
		Inspection	•	Tube	_	Cut Too Short		Misread	1		ower Loss/	Surge	Other
		Ripples in			_	Drill Holes	_	Offset		_			
		Torque W			n [_	Drawing	L	4	Calibration	_			
		Turning So				Finish	_	1	Sequence	_			
	Wave/Twist in Tube				Folio	Outside Dimensions						,	

Work Ord		5801		*105			Page 2				
Item ID: Revision ID:	D3121-144			Accept	*N900040	1100)*	Setup	Start	*N:	S1*
Item Name:	Bracket Asset	nbly							Stop	*N:	S2*
Start Date: Required Date: Reference:	8/19/13 9/03/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:			_			
Approvals:	Process Pla	an:	Date:	Tooling:	Date:			Run	Start	*N	R1*
	QC:			_ SPC (Y/N):	Date:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
*130		QC8- Inspect parts - sec	ond check	0.00	mx 13/09/16		_8	H			
QC Quality Control		Memo		0.00			Q	_			
140				0.00				•			01
140 Small Fab		Small Fab Memo		0.00			8X	<u>-</u>			5/37
Small Fab			3121-143 as per Dwg D3	121.							•

150

QC5- Inspect part completeness to step on W/O

DAS 27 9-89

Quality Control

Memo

0.00 B 9 K

NCR:	Yes	/	No

												DQA:	Date:	
NCR: Y	'es	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UP	DATE	•		
												QA Closed:	Date:	
Nork Orde	r:						DISPOSITION				AGAINST D	EPARTMENT	PROCESS	·
Part N	lo			***************************************			Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo.						Work Order Update]		Large Fab	Composite		Supplier	
Root					Des		otion of work order update		nitial		tion	Sign &		
Cause	_	Date	Step	Qty		С	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data	_													
quip/Tooling	_												•	
perator Naterial	\dashv							1						
etup	\dashv									<u>.</u>		-	n	
thér			:											
rocess		ļ												
upplier					•					-				
raining														
napproved														
							F	ΑUI	T CATE	GORY				
Landi	ng G	Gear					General		-			_		
		Bending					Bend		Grain		L	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (O/S		BOM/Route	L	Hardwa		<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks				<u> </u>	Broken/Damaged		1	on incomplete	<u> </u>	Part Incorred	├ ─	Weld
		Crushed/0	Crimped			_	Burrs	<u> </u>	4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				_	Contamination	_	Mainte			Part Moved		
		Heat Trea					Countersink	<u></u>	Mislabe		L	Positioned V		٦.
	-	Inspection	•	Tube		<u> </u>	Cut Too Short	_	Misread	1	L	Power Loss/	Surge	Other
		Ripples in					Drill Holes	_	Offset					····
		Torque W			า	<u> </u>	Drawing		4	Calibration				
		Turning Se					Finish	<u></u>	i i	Sequence -	-			
		Wave/Tw	ist in Tub	oe .		l	Folio		Outside	Dimensions				

Work Ord August-19-13				*105	5801*							Page 3
Item ID: Revision ID: Item Name:	D3121-144 Bracket Asse			Accept	*N900	<u>040</u>	100) *	Setup	Start Stop	14	S1* S2*
Start Date: Required Date Reference:	8/19/13 : 9/03/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:						
Approvals:	Process P		Date:	Tooling: SPC (Y/N):		ate:]	Run	Start Stop	"	R1* R2*
Sequence ID/ Work Center I 160 *160* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ock Location	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

Quality Control

Memo

0.00

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	CONFOR	MANCE / U		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No NCR No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling										-	
Operator											***
Material											
Setup									<u>.</u>		
Other											
Process											
Supplier											
Training											
Unapproved	1										
					F	AULT CAT	EGORY				

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Picklist Print

August-19-13 11:28:06 AM

Work Order ID: 105801

105801

D3121-144 Parent Item:

D3121-144

Parent Item Name:

Bracket Assembly

Start Date: 8/19/13

Required Date: 9/03/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

IPP Rev.C. New Dimensions for Blank Size, 08-07-23 ILM, Verified By EC.

	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3121-241		Manufactured	No			100	Each	39.0000	2	16	DA	
D3121-241	1						7		**	_4	/)13 _/	09/16
Douring 1 assembly				Location	1	Loc	Qty	Loc Code			/	B10562
				FG			14		_		_	-10/62
					89826		4				_	B10>00
					95927		10					+ '
				ST235	103892		21 21			5		
				ST235A			4		_		_	
				31233A	102098		2				_	
					102693		2				_	
D3121-21		Manufactured	No			140	Each	50.0000	2	16	01	. / /
D3121-21	•								**		///	2/09/16
Bolt		•								T)	7	
				Location	<u>1</u>	<u>Loc</u>	<u>Oty</u>	Loc Code				100000
				ST235			50		Marrie .		- B	5/056/7(
					102053		1				-	
					102765 99292		45 4		-		_	
M174B1.250X02.000		Purchased	No			140	f	22.4000	0.368	3.09894	- 7	
*M174R1 2!	50X02								**			L 12-9-10
				Location	<u>1</u>	<u>Loc</u>	<u>Oty</u>	Loc Code				
•				MAT049	•		22.4		_		_	
					114899		2			0 5	_	

20.4

M126132

NCR:	Yes	/	No

DQA: _____Date: ____

NCR: Y	'es	/ No				WORK ORDER NON-	CON	IFORN	AANCE / UP	DATE			_		
											Q	A Closed:	Da	te:	
Nork Orde	er:					DISPOSITION				AGAINST D	DEPA	RTMENT/	PROCESS		
Part N	-					Rework Scrap			Skid-tube Machining	Crosstube Small Fab		Proc	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	lo.					Use-as-is Work Order Update	}		noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	-	Other
Root					Descri	ption of work order update	İr	nitial	Ac	tion		Sign &		П	
Cause		Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
oc/Data															
quip/Tooling															
perator							ĺ				İ				
/laterial														l	
etup															
ther															
rocess	\neg														
upplier			:												
raining														ŀ	
Inapproved							1					j			
						F	AUL	T CATE	GORY		-		_		
Landii	ng G	iear				General									
		Bending				Bend		Grain		Г	\neg o	valized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	П	Hardwa	re		o	ver/Under 1	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	П	Inspecti	ion Incomplete	Ţ	Pa	art Incorrec	:t	П	Weld
		Crushed/0	Crimped			Burrs	П	Instruct	ions Incomplete/	'Unclear	Pá	art Lost/Mis	ssing		Wrong Stock Pulled
		Cuffs	•			Contamination	П	Mainte	nance		Pa	art Moved	,		•
		Heat Trea	ıt			Countersink	П	Mislabe	eled		Po	ositioned W	/rong		
		Inspection		Tube		Cut Too Short		Misread	J		Po	ower Loss/S	Surge		Other
		Ripples in				Drill Holes	П	Offset		_					
		Torque W		xtrusio	n	Drawing	П	Out of 0	Calibration						
		Turning S				Finish	H	Out of S	Sequence				· · · · ·		
		Wave/Tw				Folio	\vdash		Dimensions		_		* ***		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	105801
Description: Bracket	Part Number:	D3121-114
Inspection Dwg: D3121 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Pr	ototype
---	---------------	----	---------

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.080	+/-0.010	.080			Len	JL-10
0.300	+/-0.010	-301				
R0.375	+/-0.010	.375	/ ,			:
1.54	+/-0.030	1.54	/			
0.350	+/-0.010	-352				
R0.25	+/-0.030	-250	/		(
Ø0.392	+0.002/-0.000	-3928			mic	SL-4
Ø0.201	* 10.005/-0.000	_198			V19V	22-10
0.100	+/-0.010	-098	/		V	
	/ 0 0 1 0	0.58				
2.540	+/-0.010	3.538				
1.590	+/-0.010	1.588				
0.160	+/-0.010	-128				
0.400	+/-0.010	-399				
1.220	+/-0.010	1-219				
1.600	+/-0.010	1.601				
3.80	+/-0.030	3.795				
1.800	+/-0.010	1.800				
R0.50	+/-0.030	-566				
0.130	+/-0.010	-130				
3.41	+/-0.030	3.385				
3.65	+/-0.030	3.650				
2.24	+/-0.030	2.225				
45°	+/-0.1°	450				
R0.25	+/-0.030	-25				
3.97	+/-0.030	3.973				
R0.38	+/-0.030	-38				
Ø0.392	+0.002/-0.000	-3928	7.			
Ø0.201	± ±0.002/-0.000	-3100	/			
0.268	+/-0.010	T	 		11-0	
R0.260	+/-0.010	-266	1		Ho	
0.080	+/-0.010	-260 -082				
0.300	+/-0.010	-302	'			
0.381	+/-0.010	-379				
0.201	+/-0.010	-201				

DART AEROSPACE LTD	Work Order:	105801
Description: Bracket	Part Number:	D3121-114
Inspection Dwg: D3121 Rev: E		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.580	+/-0.010	-580				
0.400	+/-0.010	390				
100°	+/-0.1°	1000				
0.032	+0.000/-0.010	.027			BG ₁	31-7
			1			
74.4157						
					·	
	·					1176
7111111111						7
	· <u>·</u>					

Measured by:	علا	Audited by:	Prototype Approval:	N/A
Date:	13-9-14	Date: 13/09/1/	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue P/O D3121-144	KJ/RF	
В	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
С	06.06.14	Dwg Rev. updated	KJ/JLM	:
D	08.01.16	Dimensions updated per Dwg Rev E	KJ/EC/DD,	
E	08.05.20	0.032 dimension was 0.32	KJ/DD ox	13/



(‡)

 \bigcirc

DESIG	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED	DRAWING NO. REV. E
DATE	411	I M	D3121 SHEET 1 OF 10
	11.07		30/102
07.	11.07		BRACKET ASSEMBLY 1:2
Α		02.04.15	NEW ISSUE
В		03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146
С		04.02.17	ADD CLEARANCE; USE -241 BEARING
D		06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000
Ε		07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)

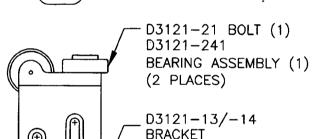


D3121-21 BOLT (1)
D3121-241	
BEARING ASSEMBLY	(1)

D3121-11 BRACKET

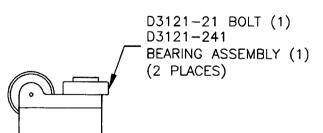
D3121-041 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-15/-16 BRACKET

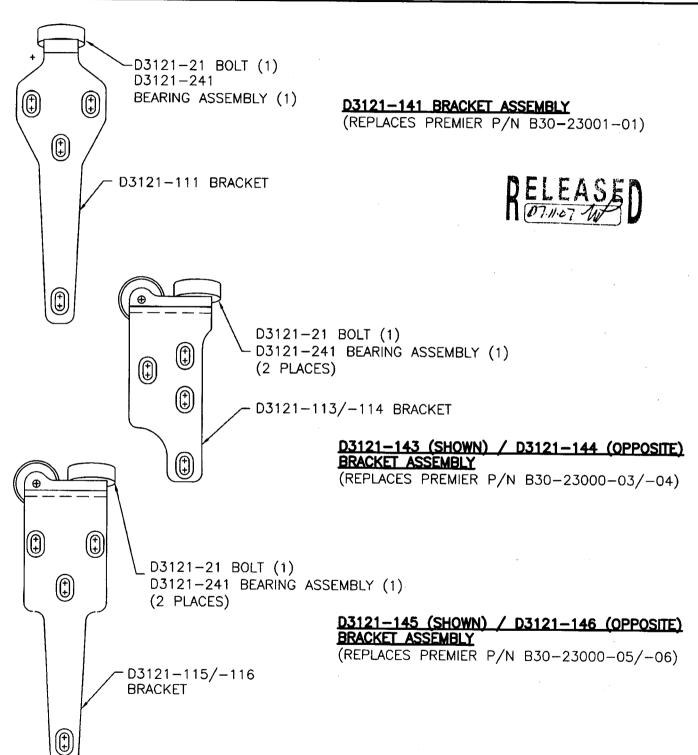
D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)

Copyright © 2002 by DART AEROSPACE LTD



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
#		D3121	SHEET 2 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	. 1:2	

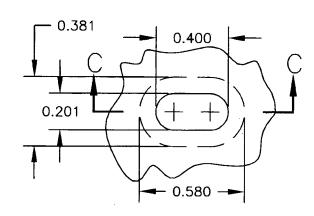


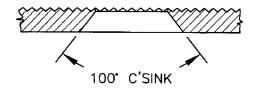
Copyright © 2002 by DART AEROSPACE LTD



	DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONT	
	CHECKED	APPROVED	DRAWING NO.	REV. E
ļ	4	一献	D3121	SHEET 3 OF 10
	DATE		TITLE	SCALE
	07.11.07		BRACKET ASSEMBLY	1:1

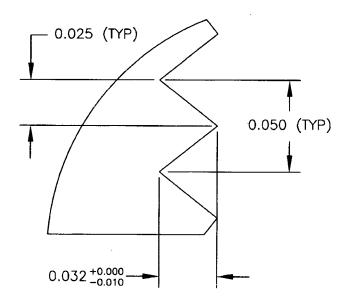
SLOT DETAIL SCALE 2:1 VIEW ROTATED





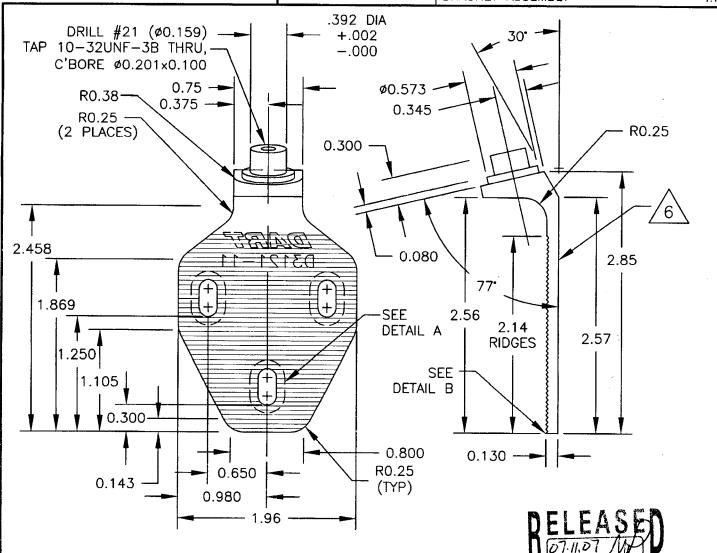
SECTION

DETAIL B: RIDGE DETAIL PARTIAL SECTION SCALE 1:20





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED,	DRAWING NO.	REV. E	
#	-#	D3121	SHEET 4 OF 10	
DATE	•	TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:1	



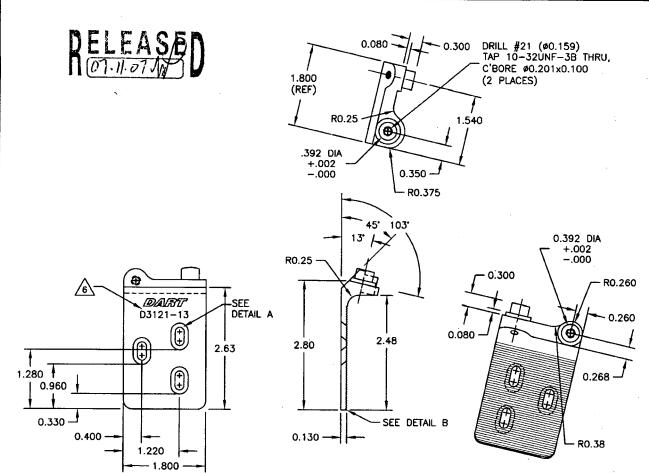
D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

Copyright © 2004 by DART AEROSPACE LTD



	DESIGN #	DRAWN BY	DART AEROS HAWKESBURY, ON	
ı	CHECKED	APPROVED	DRAWING NO.	REV. E
	#		D3121	SHEET 5 OF 10
	DATE		TITLE	SCALE
	07.11.07		BRACKET ASSEMBLY	1:2



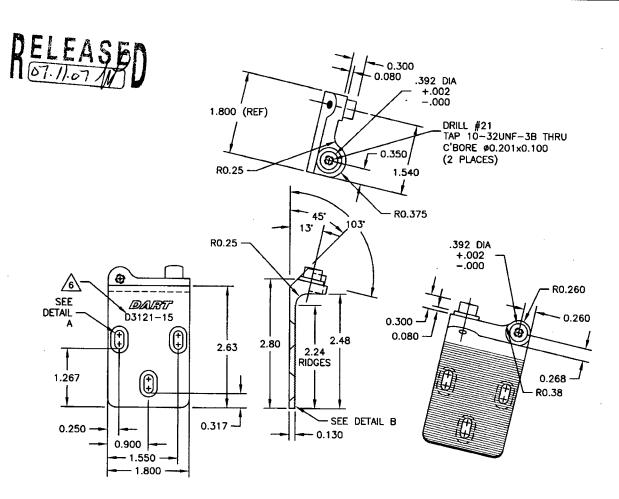
D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

Copyright @ 2002 by DART AEROSPACE LTD



DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E SHEET 6 OF 10	
DATE	<u></u>	TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



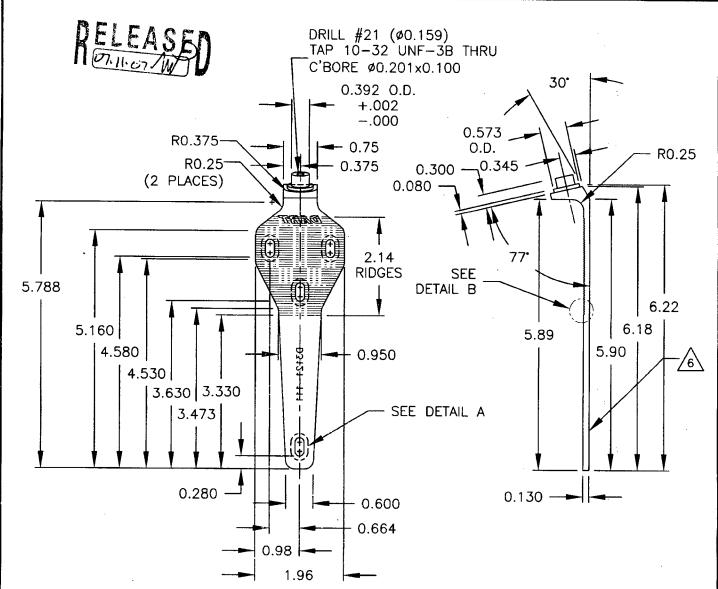
D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

Copyright © 2002 by DART AEROSPACE LTD



DESIGN	DRAWN BY	I DARI AFRONDACE III	
CHECKED	APPROVED	DRAWING NO.	REV. E
9#		D3121	SHEET 7 OF 10
DATE	-	TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



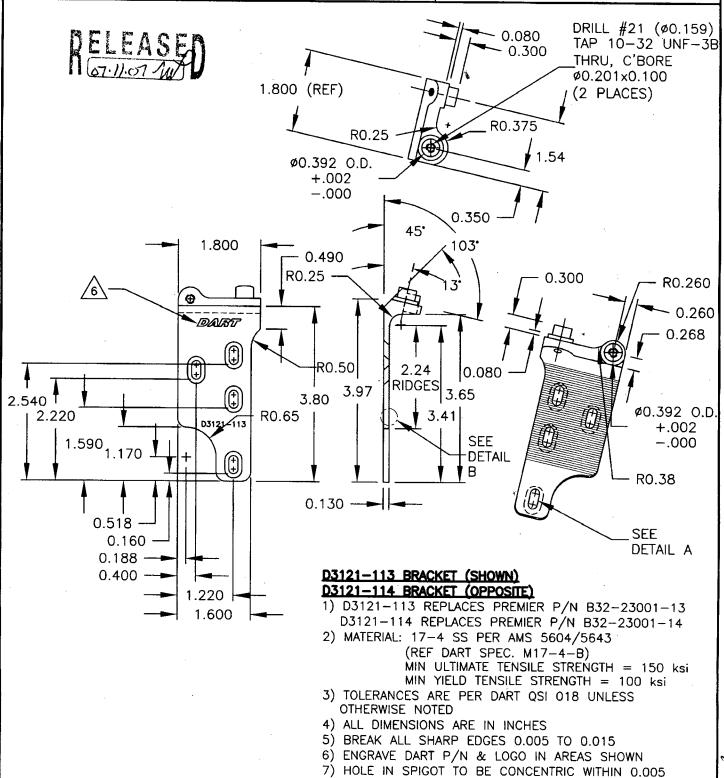
D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

Copyright @ 2002 by DART AEROSPACE LTD



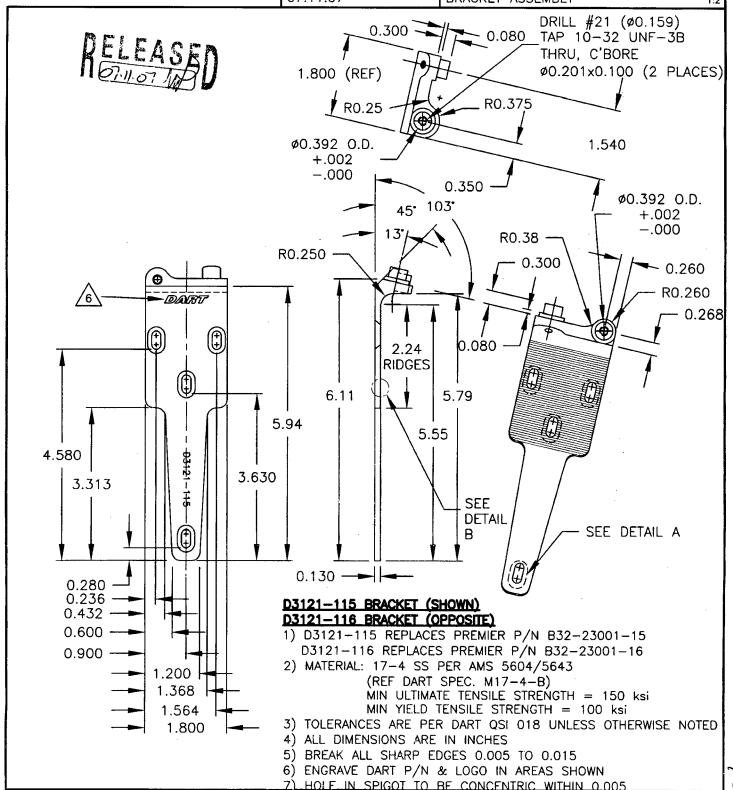
DES	SIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHE	CKED	APPROVED	DRAWING NO.	REV. E SHEET 8 OF 10
DAT	E	<u> </u>	TITLE	SCALE
07	.11.07		BRACKET ASSEMBLY	1:2



Copyright @ 2002 by DART AEROSPACE LTD

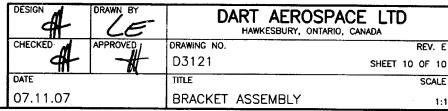


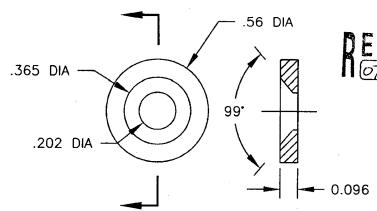
DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTAR	
CHECKED	APPROVED	DRAWING NO.	REV. E
4	-#	D3121	SHEET 9 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



Copyright @ 2002 by DART AEROSPACE LTD

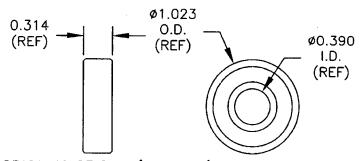






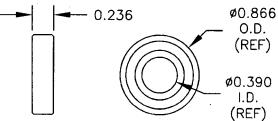
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- ALL DIMENSIONS ARE IN INCHES

Copyright © 2002 by DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

0.375 -

D3121-21 BOLT (SCALE 1:1)

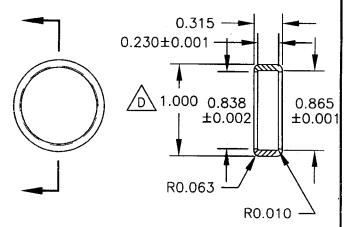
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.080

TAP 10-32 UNF-3A

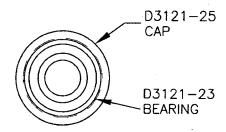
0.050 TO 0.060

- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25
- (REF DART SPEC. M-DELRIN-R1.250) 2) TOLERANCES ARE PER DART QSI 018 UNLESS
- OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)